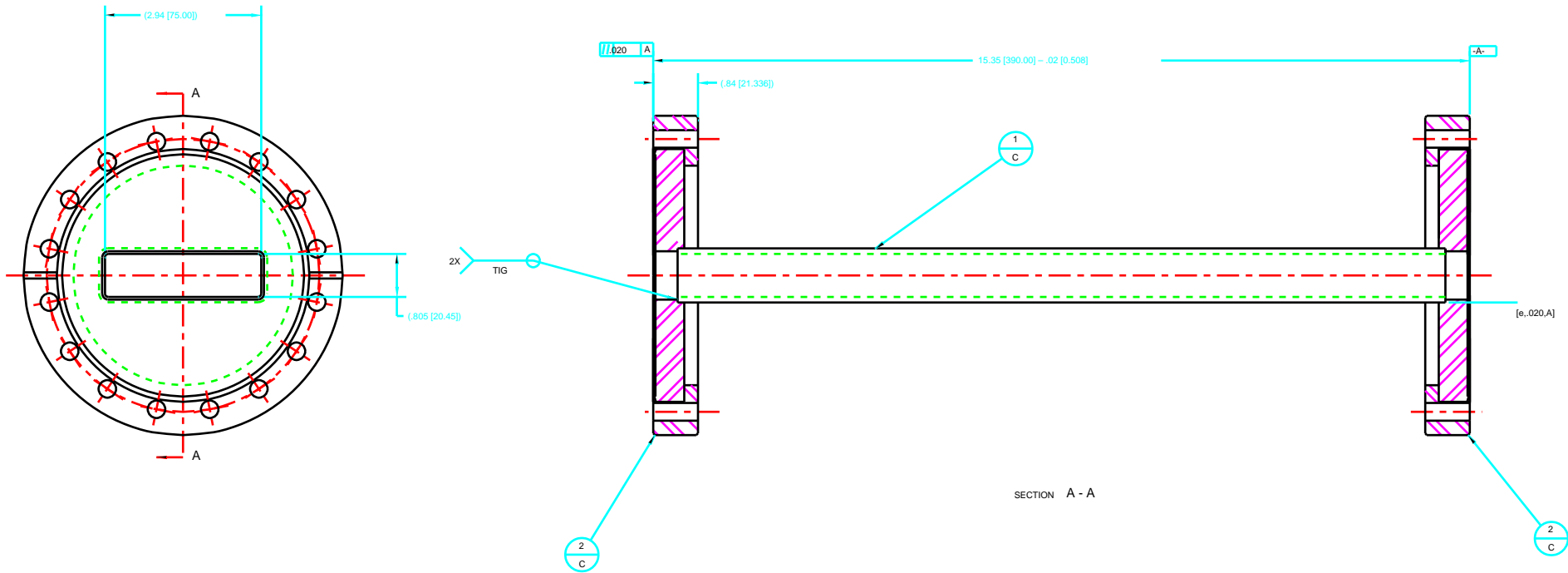


(D)	PLOT SCALE: 1=1	DWG. SCALE: 1	A08344
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NOTES:

1. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
2. CHAMBER ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS: ALCATEL SAM-110TCL DU PONT CEC 24-120B VARIAN MS-9, MS-90 OR MS-18
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.
5. ELECTRO POLISHING IS NEEDED BEFORE WELDING, PRIOR TO ELECTROPOLISHING, THE CHAMBER NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN. THE CHAMBER VACUUM SIDE SURFACE ROUGHNESS SHALL BE BETTER THAN 63 MICROINCH RMS AFTER ELECTROPOLISHING.
6. WELD SHALL BE GAS TUNGSTEN ARC (GTAW) OR TUNGSTEN INERT GAS (TIG) ON VACUUM SIDE OF JOINTS.

FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

2 P4105090403-410100-01 END FLANGE		2	
1 P4105090403-410100-01 RECTANGULAR CHAMBER		1	
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC
PARTS LIST			
LOG NUMBER A2416900		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
DRAWN BY E. TORRES	DATE 3/15/96	CHIEF DESIGN ENGINEER D. SHU	DATE 4/1/96
CHECKED BY J. CHANG	DATE 3/22/96	PROJECT MGR. T.M. KUZAY	DATE 4/2/96
DESIGNER CHANG/TORRES	DATE 3/15/96	APPROVED/RELEASED	
RESPONSIBLE ENGINEER J. CHANG	DATE 3/22/96		
MATERIAL SEE PARTS LIST		SCALE 1:1	SHEET 1 of 1
DRAWING NUMBER P4105090403-410100-00			

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE